

Date: Thursday, 6/15/2006 1:51:27 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT ASSEMBLY		
Job Number	: 27593		Part Number	: D3278041		
Estimate Number	: 10464		Drawing Number	: D3278 REV. B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 6/15/2006 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 7/5/2006 Qty: 30 Um: Each		
Previous Run	: 24568					
Written By	: See comment below					
Checked & Approved By	: KJ/JLM					
Comment	: Est:A 04.04.19 New issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	27593A	SUPPORT
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Comment: Sub-Component SUPPORT

2.0	27593B	SUPPORT
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Comment: Sub-Component SUPPORT

3.0	D32781	SUPPORT
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Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

SUPPORT

Pick:

Qty	Part Number	Description	Batch
1	D3278-1	Support	<u>B27593A</u>

FF 06-07-24

30

4.0	D32782
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Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

SUPPORT

Pick:

Qty	Part Number	Description	Batch
1	D3278-2	Support	<u>B27593B</u>

FF 06-07-24

30

5.0	D32783
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)
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Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3278-3	Spacer	<u>B24098 (x20)</u>

B22971 (x1)

FF 06-07-24

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:51:27 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 27593

Part Number: D3278041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	MS20426AD37	RIVET
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 120.0000 Each(s)

RIVET

Pick:

Qty Part Number

4 MS20426AD37 Rivet

Description

Batch

M 16527

FF 06.07.24

PTU

30

7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet spacers with support as per Dwg D3278

FF 06.07.24

30

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

9.0	D22301	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Mounting Lug

Pick: Packing Kit

Qty Part Number

2 D2230-1 Mounting Lug

Description

Batch

B 25553

FF 06.07.24

30

10.0	AN413A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4-13A Bolt

Description

Batch

B 101149

FF

06.07.24

30

11.0	AN960JD416	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 120.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

4 AN960JD416 Washer

Description

Batch

101369

FF

06.07.24

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-24	6.0	Substitute -7 rivet for a -6. This time. -7 keep going crooked.				<i>BS</i> <i>order</i>	<i>607-24</i>

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: *BS*Date: *06/07/26*

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Thursday, 6/15/2006 1:51:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 27593

Part Number: D3278041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	MS21042L4	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	MS21042L4	Nut	B100743

FF 06.07.24

30

13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

DO NOT TIGHTEN BOLTS

Identify as D3278-041

FF 06.07.24
SAD 06.07.25

24

14.0	QC5	INSPECT WORK TO CURRENT STEP
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J 06.07.25 (30)

Comment: INSPECT WORK TO CURRENT STEP

15.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST105

ST 06.07.25 (30)

16.0	DC	DOCUMENT CONTROL
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(30)

Comment: DOCUMENT CONTROL

Inspection Level 21

ST 06.07.06

Job Completion



AJ 06.07.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

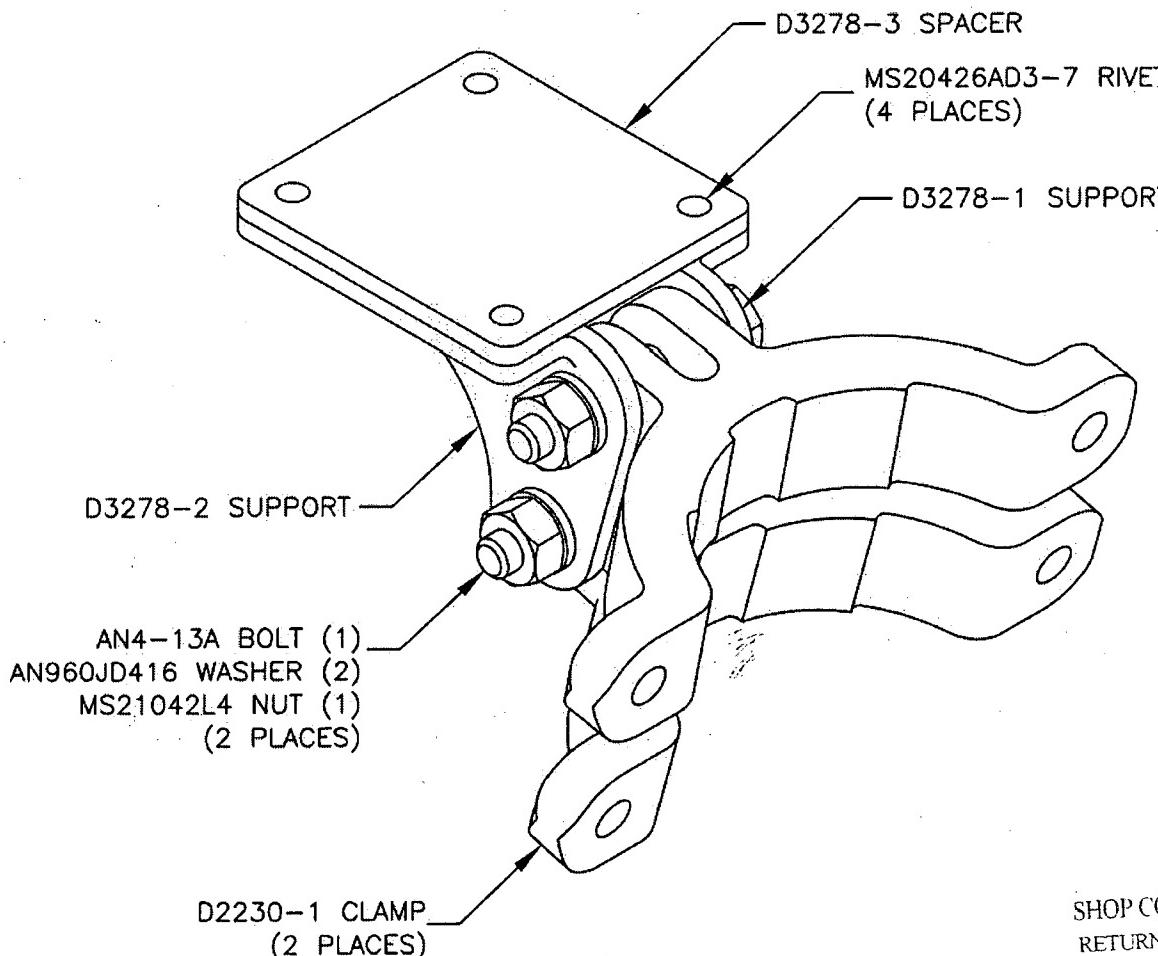
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
05.04.04

D3278-041 SUPPORT ASSEMBLY



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WORK ORDER
NO. 27593

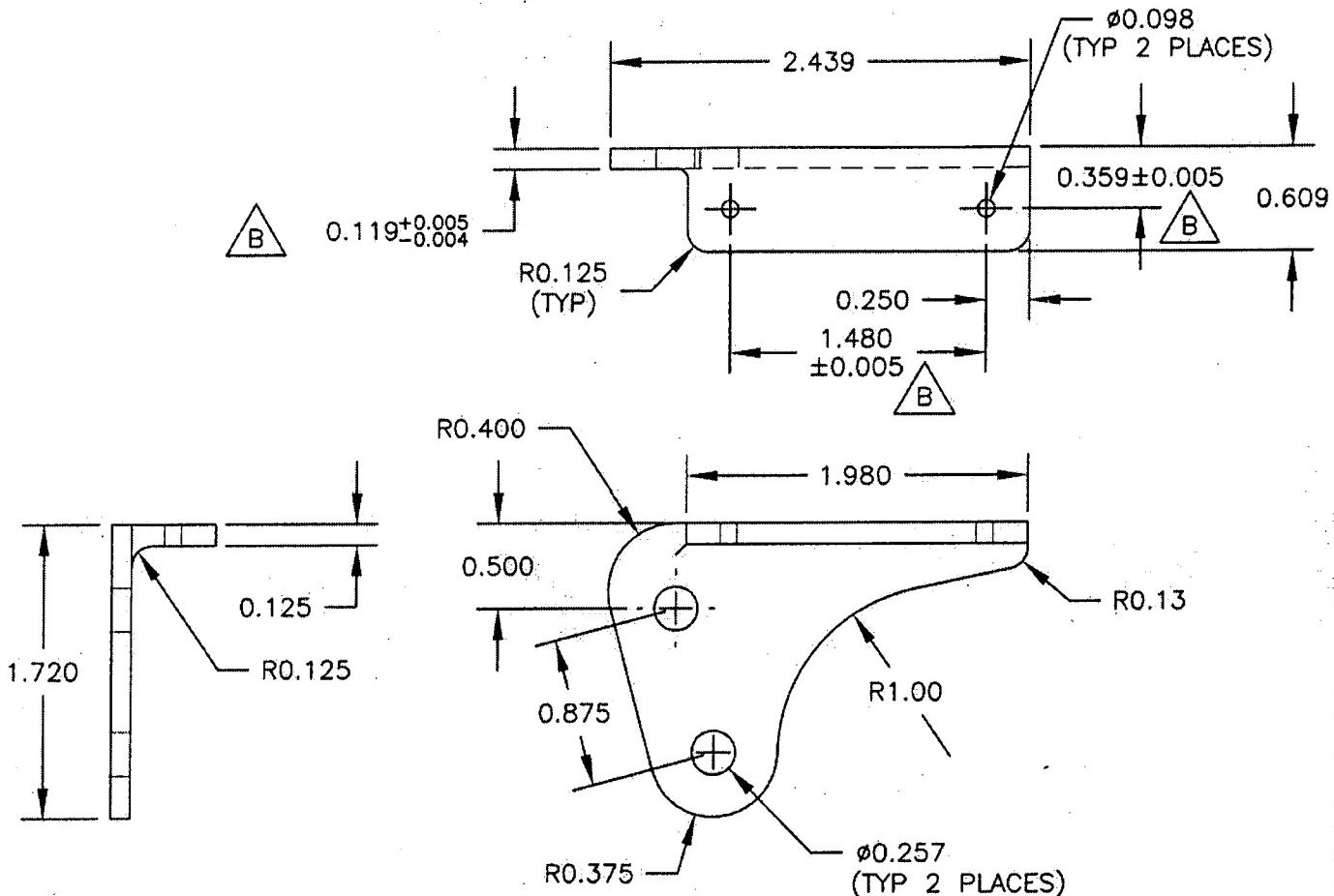
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278	REV. B SHEET 2 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[initials]*D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/HM)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO. 27593

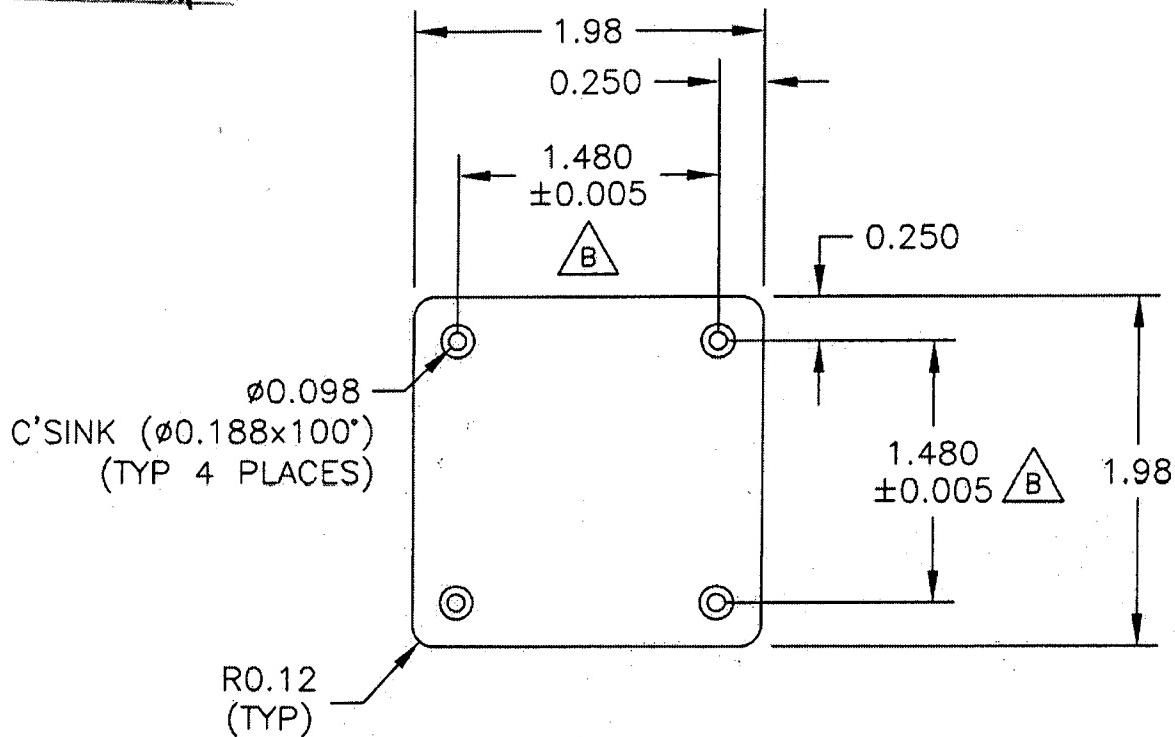
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278
DATE 05.03.31		REV. B SHEET 3 OF 3 TITLE SCALE 1:1 SUPPORT ASSEMBLY

RELEASED

05.04.04 *[initials]*D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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